

Work Order ID 108957

108957

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October-30-13 2:35:26 PM

Item ID: D4936-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Rev A - Stop *NS2*
 Item Name: Clamp
 Start Date: 30/10/2013 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 31/10/2013 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4936 | Rev A | | | | | | | | |
| 100 | Manufacture as per dwg | 0.00 | | | | 4 | 0 | | WSP 13/10/30 |
| *100* | | | | | | | | | |
| Mill Conv | Memo | 0.00 | | | | | | | |
| Conventional Milling Machine | | | | | | | | | |
| 110 | QC2-Inspect parts off machine FAI/FAIB | 0.00 | | | | 4 | 0 | | CA 13-10-30 |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC3-Inspect Part Finish | 0.00 | | | | 4 | 0 | | WSP 13/10/31 |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 105 | QC2 | | | | | 4 | 0 | | WSP 13/10/31 |

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Item ID: D4936-1

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Clamp

Start Date: 30/10/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/10/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 140 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Black Sandtex (Ref: 4.3.5.7) per QSI005 4.3 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

4 φ 13-10-31. DAS 34 9-89

4 φ 13-10-31. DAS 34 9-89

START: 12:40
OVEN T: 320
FINISH: 1:10

Work Order ID 108957

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Item ID: D4936-1 Accept *N900040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Clamp
Start Date: 30/10/2013 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 31/10/2013 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | 4 | all | 13/10/31 | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Ship 13/11/31 (4)

MLJ 13-11-07

MLJ
13-10-31

Picklist Print

October-30-13 2:35:23 PM

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Work Order ID: 108957

Parent Item: D4936-1

Parent Item Name: Clamp

Start Date: 30/10/2013

Required Date: 31/10/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-10-21 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.375X00.750 6061T6 BAR .375 x .750 | | Purchased | No | | | | f | 14.9990 | | 1 | | | |

Location

Loc Qty

Loc Code

MAT002

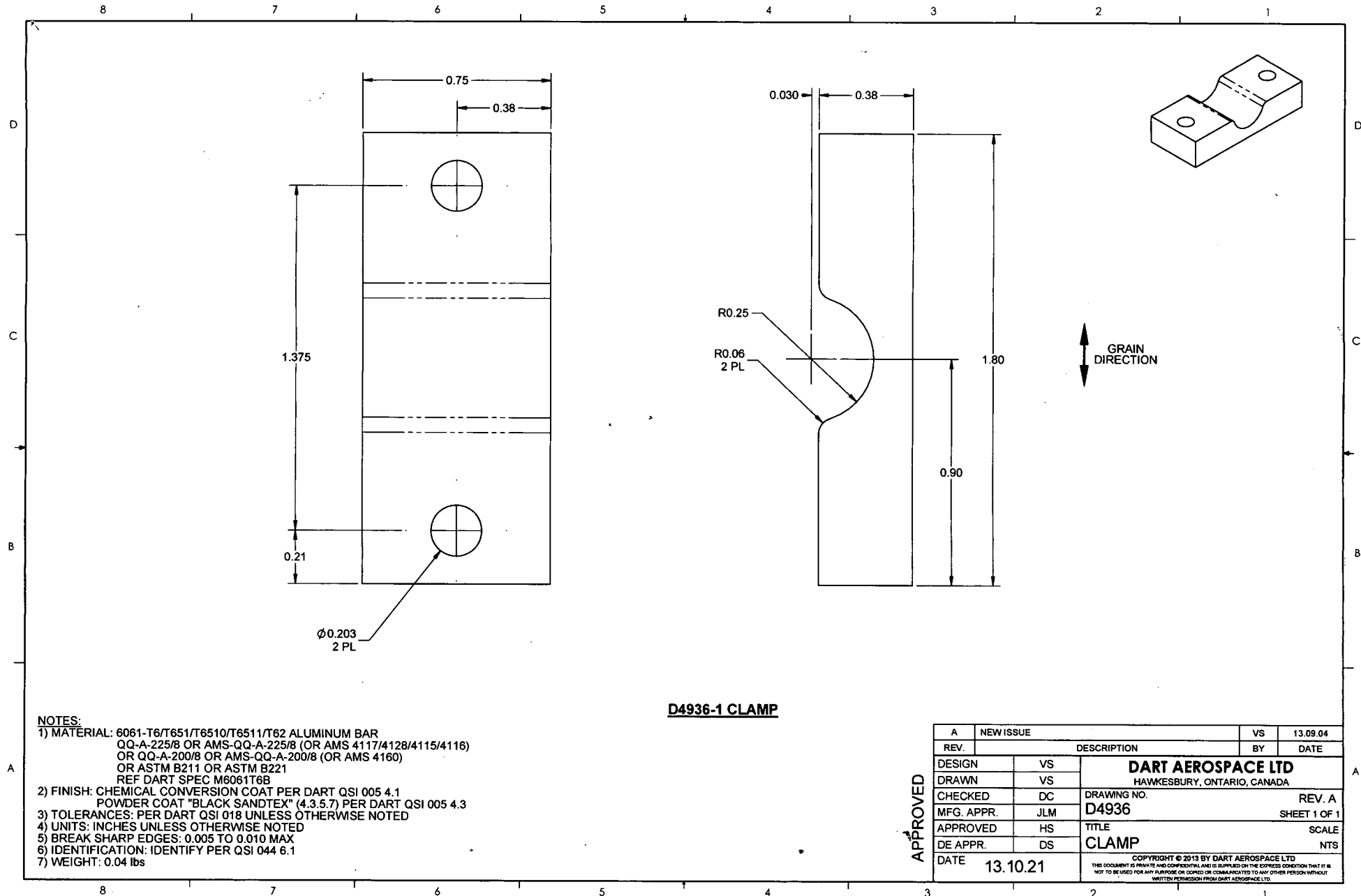
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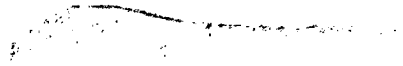
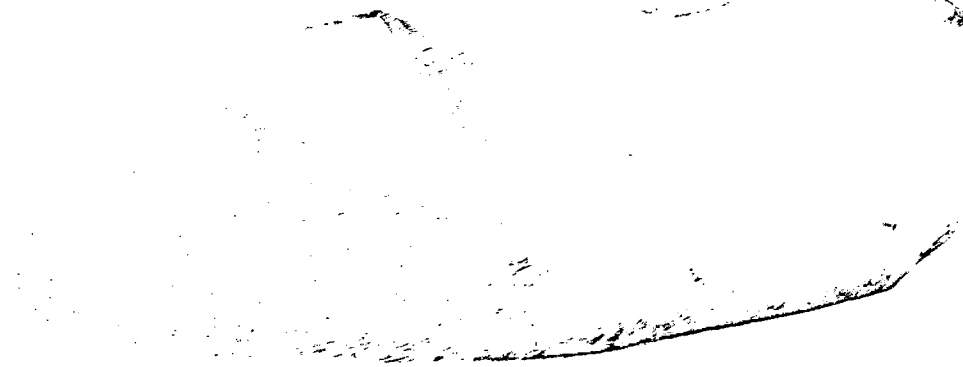
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13/10/30

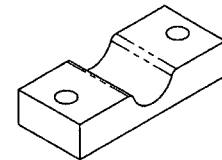
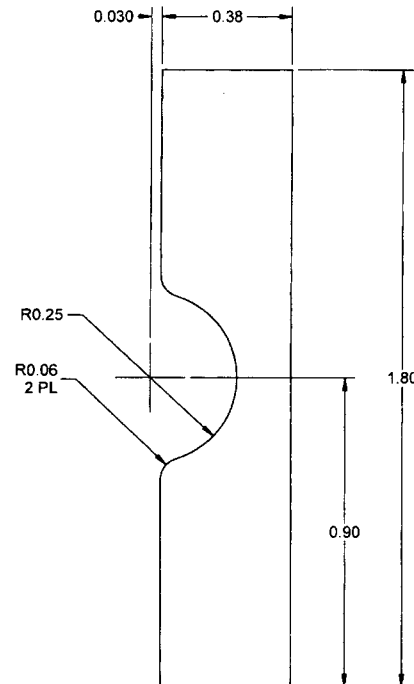
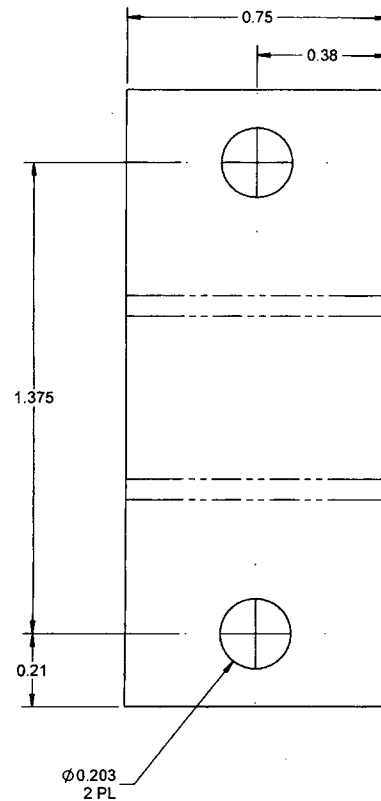




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GRAIN
DIRECTION

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

D4936-1 CLAMP

| | | | | | |
|---|-------------|--|--------------|----|----------|
| A | | NEW ISSUE | | VS | 13.09.04 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | VS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | VS | | | | |
| CHECKED | DC | DRAWING NO. | REV. A | | |
| MFG. APPR. | JLM | D4936 | SHEET 1 OF 1 | | |
| APPROVED | HS | TITLE | SCALE | | |
| DE APPR. | DS | CLAMP | NTS | | |
| DATE | 13.10.21 | | | | |
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